

Date: Monday, 2/19/2007 8:07:46 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARPLATE
Job Number : 30751	
Estimate Number : 12731	
P.O. Number : N/A	Part Number : D353535 <i>Rev A</i>
This Issue : 2/19/2007 S.O. No. : N/A	Drawing Number : D3535 <i>UNDER REVIEW PH</i>
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB	Drawing Revision : U/R
Previous Run : N/A	Material : N/A
Written By : <i>[Signature]</i>	Due Date : 2/26/2007 Qty: 12 Um: Each
Checked & Approved By : <i>[Signature]</i> 07.02.19	
Comment : Est Rev: A New Issue 07-02-15 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S20GA	304/316 .040 Sheet
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Comment: Qty.: 0.8423 sf(s)/Unit Total : 10.1077 sf(s)

304/316 .040 Sheet

(M304S20GA)

Batch: *H101873**SAD 07/02/25 12*

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3535

Dwg Rev: *A*Prog Rev: *A*

2-Deburr if necessary

*SAD 07/02/25**SAD 07/06/27 12*

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	----------------------------------------



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/02/25 12

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

*SA 07.02.25**12*

5.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE

1-Deburr if necessary

2-Form on Brake as per Dwg D3535 using Jigs DT8261 and DT8326

3-Identify as D3535-35.

*SAD 07/02/27**(12)**MF 07-03-06**12*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 07/15/08
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 2/19/2007 8:07:46 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 30751

Part Number: D353535

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/03/07 (12)

7.0

POWDER COATING

POWDER COATING



M101601



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

07/03/07 (12)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07/03/07 (12)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location PP

07/03/07 (12)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/03/08

Job Completion



07/03/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

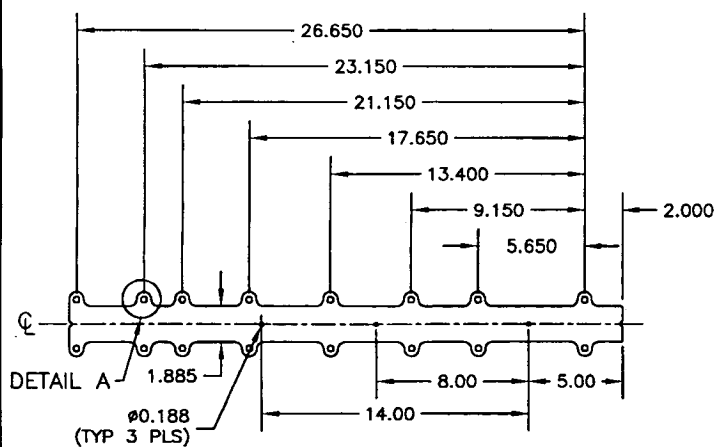
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

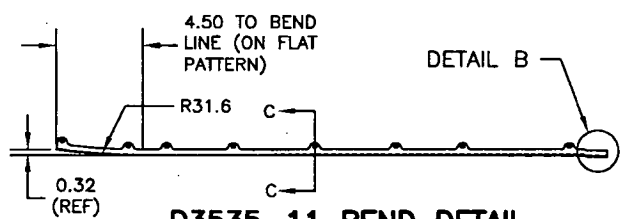
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07.02.12

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CB	CB	PORT HADLOCK, WA
CHECKED PH	APPROVED K	DRAWING NO. D3535
DATE 06.10.25	TITLE WEARSHOE	SHEET 1 OF 7
A	06.10.25	NEW ISSUE
		SCALE 1:10



D3535-11F FLAT PATTERN

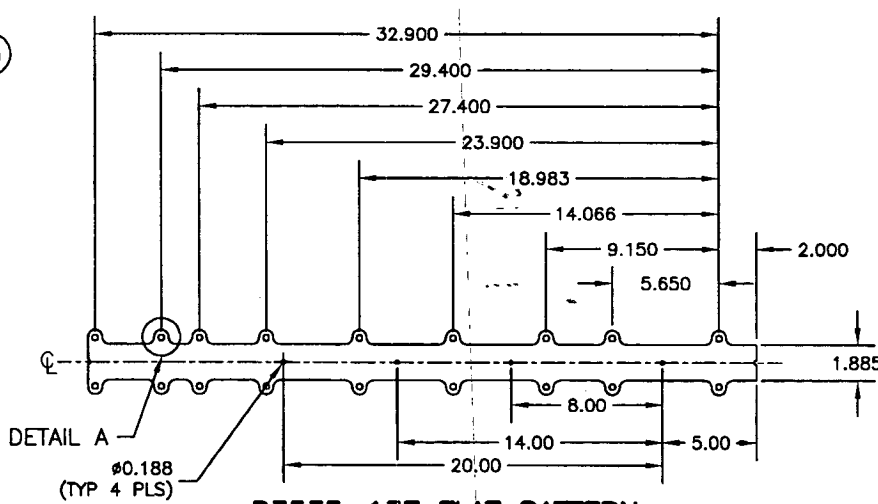


D3535-11 BEND DETAIL

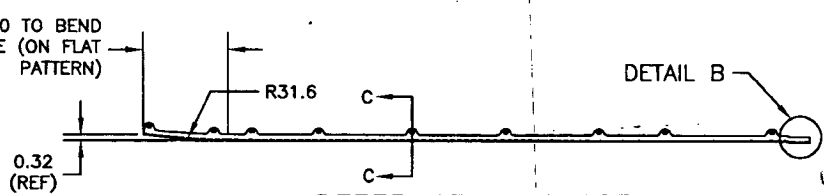
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WORK ORDER
NO. 30751

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET, 20 GAUGE (0.038 THICK, REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION



D3535-13F FLAT PATTERN

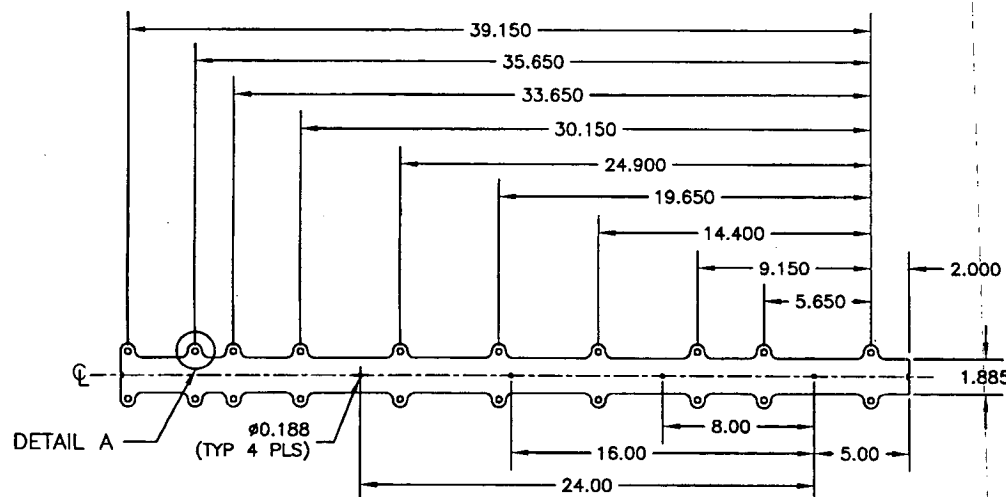


D3535-13 BEND DETAIL

DART

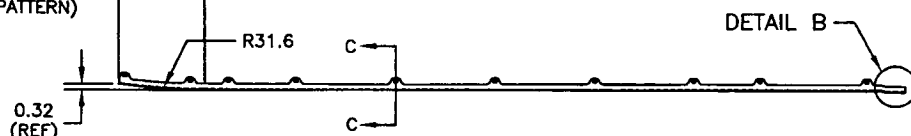
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CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	TITLE	D3535	WEARSHOE
				REV. A
				SHEET 2 OF 7
				SCALE
				1:10

07.02.12
#



4.50 TO BEND
LINE (ON FLAT
PATTERN)

D3535-15F FLAT PATTERN

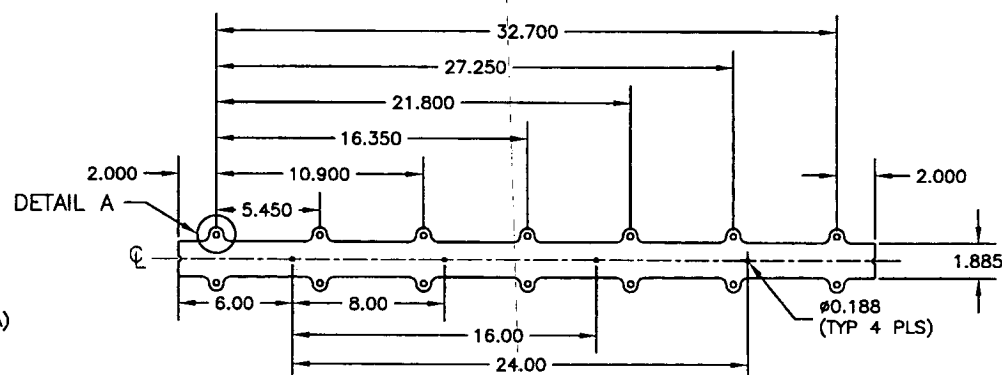


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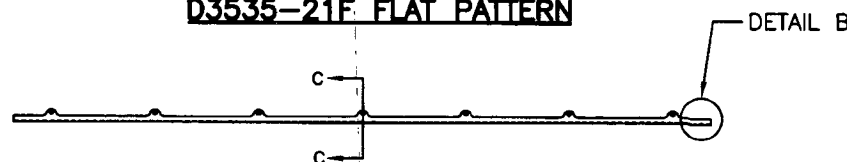
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D3535-21F FLAT PATTERN

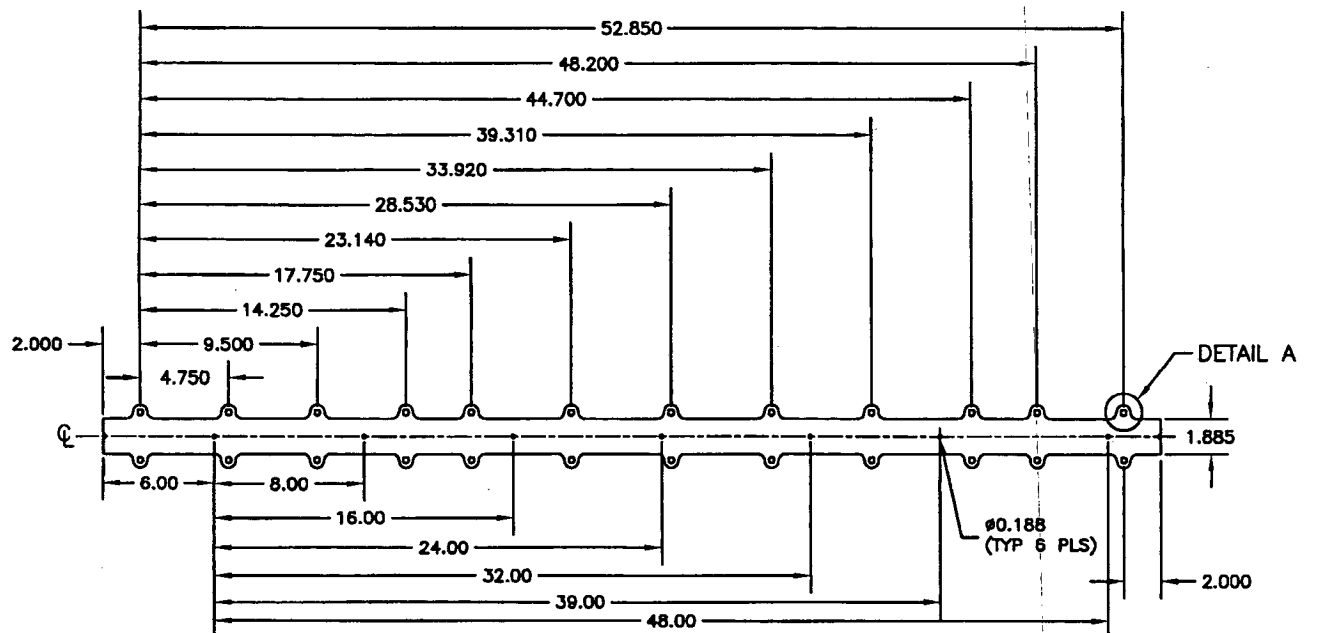


D3535-21 BEND DETAIL

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DATE 06.10.25	TITLE WEARSHOE	SCALE 1:10	

07.02.12
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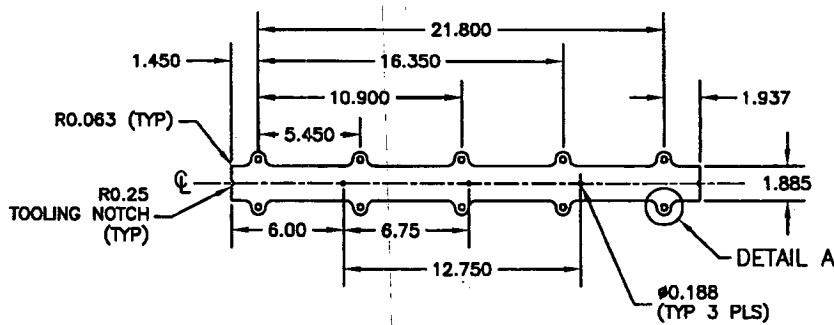


D3535-23F FLAT PATTERN

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D3535-25F FLAT PATTERN



D3535-25 BEND DETAIL

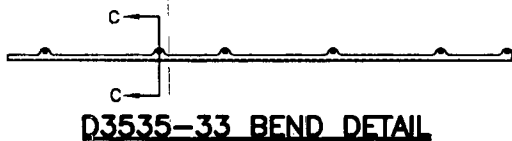
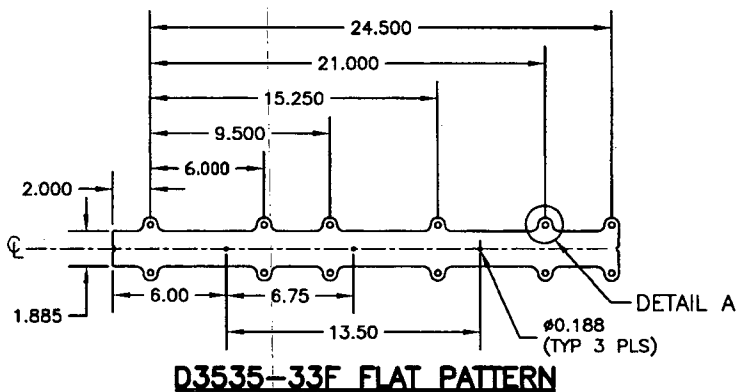
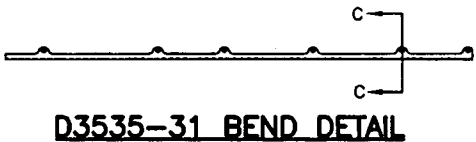
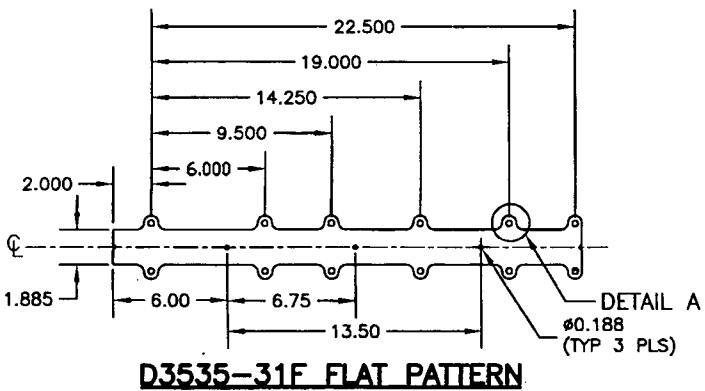
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DATE 06.10.25	TITLE WEARSHOE	SHEET 4 OF 7	SCALE 1:10

070212 CH

**NOTES**

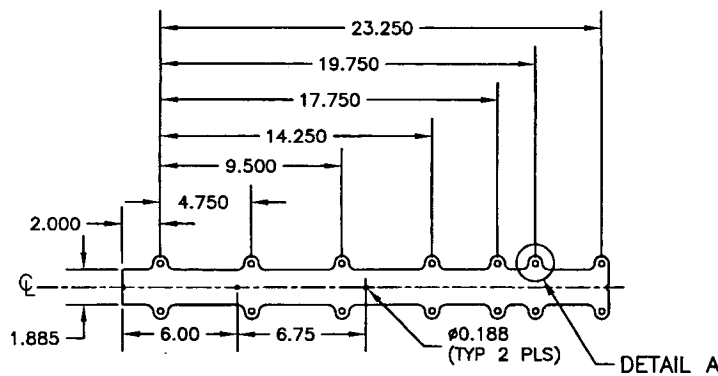
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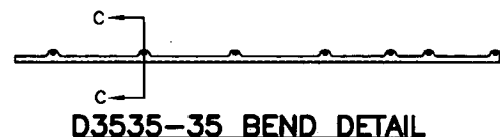
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DATE 06.10.25	TITLE WEARSHOE	SHEET 5 OF 7
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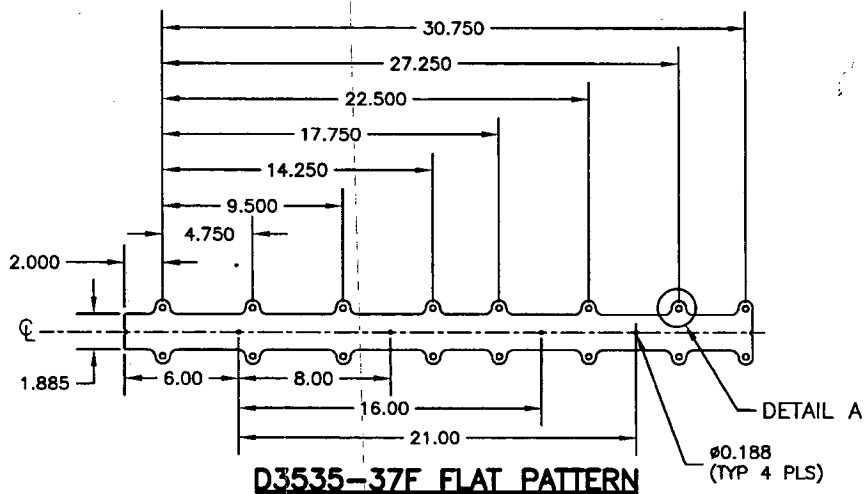
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D3535-35F FLAT PATTERN



D3535-35 BEND DETAIL



D3535-37F FLAT PATTERN



D3535-37 BEND DETAIL

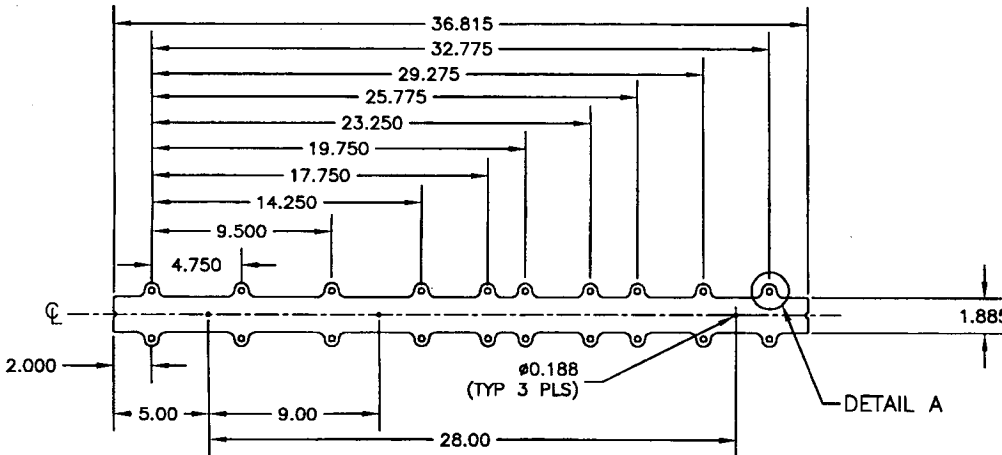
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- NOTES**
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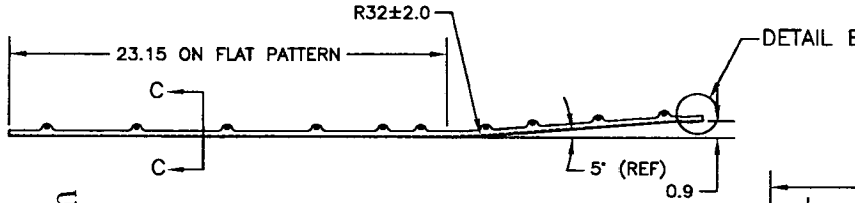
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DATE 06.10.25	TITLE WEARSHOE	SHEET 6 OF 7	
		SCALE 1:10	

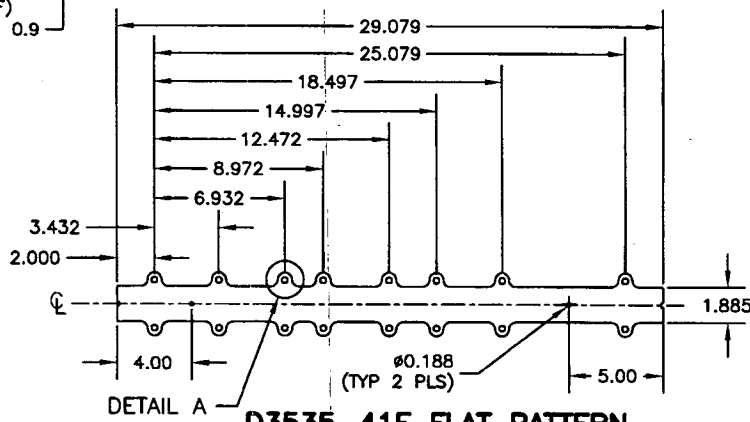
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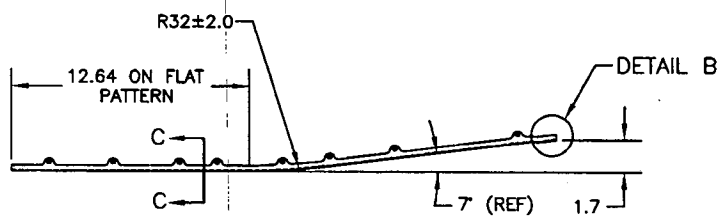
D3535-39F FLAT PATTERN



D3535-39 BEND DETAIL



D3535-41F FLAT PATTERN



D3535-41 BEND DETAIL

NOTES

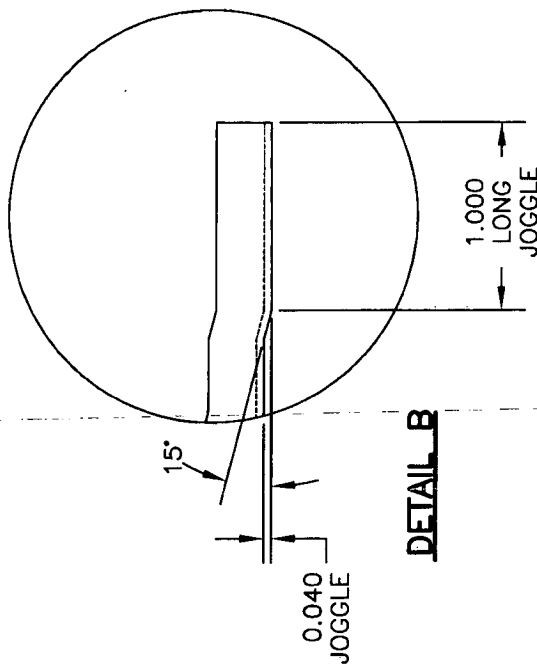
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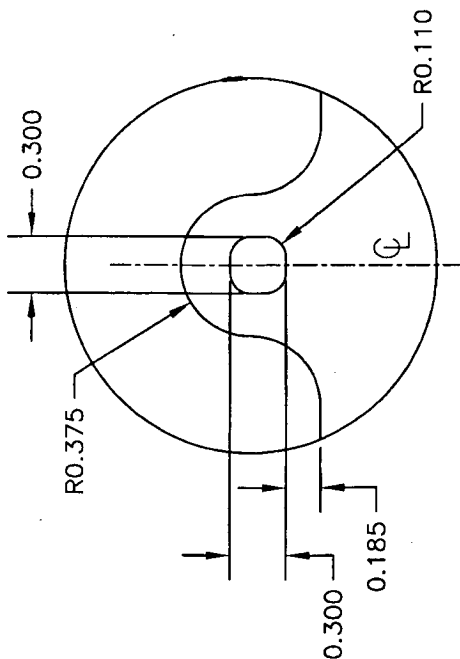


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DATE 06.10.25		TITLE WEARSHOE	SCALE 1:1

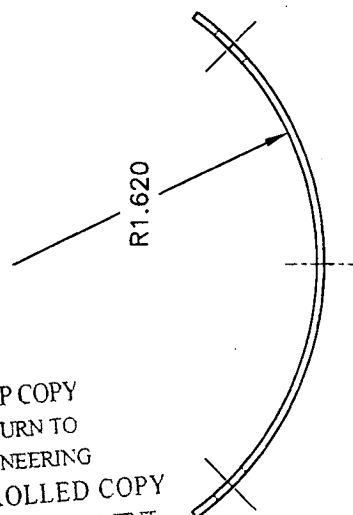
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DETAIL B



DETAIL A



SECTION C-C

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